

Date: Monday, 9/11/2006 3:41:18 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET		
Job Number	28470	Part Number	: D3246041		
Estimate Number	12473	Drawing Number	: D3246 REV A1		
P.O. Number	N/A	Project Number	: N/A		
This Issue	9/11/2006	S.O. No.	: N/A		
Prsht Rev.	NC	Drawing Revision	: A1		
First Issue	N/A	Material	: N/A		
Previous Run	27670	Due Date	: 9/18/2006		
Written By		Qty:	4 Um: Each		
Checked & Approved By					
Comment	: Est Rev:A New Issue 06-06-22 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.3252 sf(s)/Unit Total : 1.3007 sf(s) 2024-T3 .050 sheet Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3246-1 Batch: <u>119053</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg Dsi9279 Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr Form as per Dwg D3246 C'sink as per Dwg D3246	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 28470		Part Number: D3246041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		11/06/11/09 (4)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		YL on 06/11/10 x 4
Chemical Conversion Coat as per QSI 005 4.1		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		FF 06-11-14
9.0	MS20426AD33	Rivet
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
Rivet		
Pick:		
Qty	Part Number	Description Batch
8	MS20426AD3-3	Rivet 1719099
10.0	MS21059L3	Nut Plate
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Nut Plate		
Pick:		
Qty	Part Number	Description Batch
4	MS21059L3	Nut Plate 1719393
Identify as D3246-041		FF 06-11-14
11.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		SB 06/11/16
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		(4)
Job Completion		
10.1 Install Nut Plates as per D3246.		FF. 06-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/15	11b	add ID+STL (pkgs) permanent change	PV	6/11/15	14	u	
			STY35				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

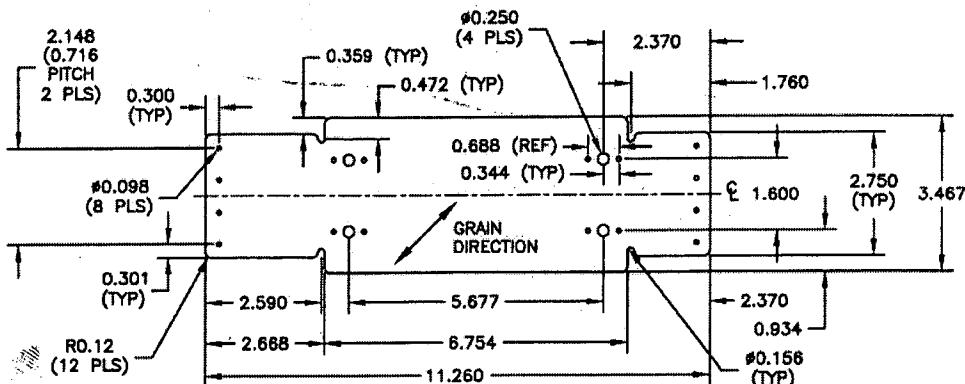
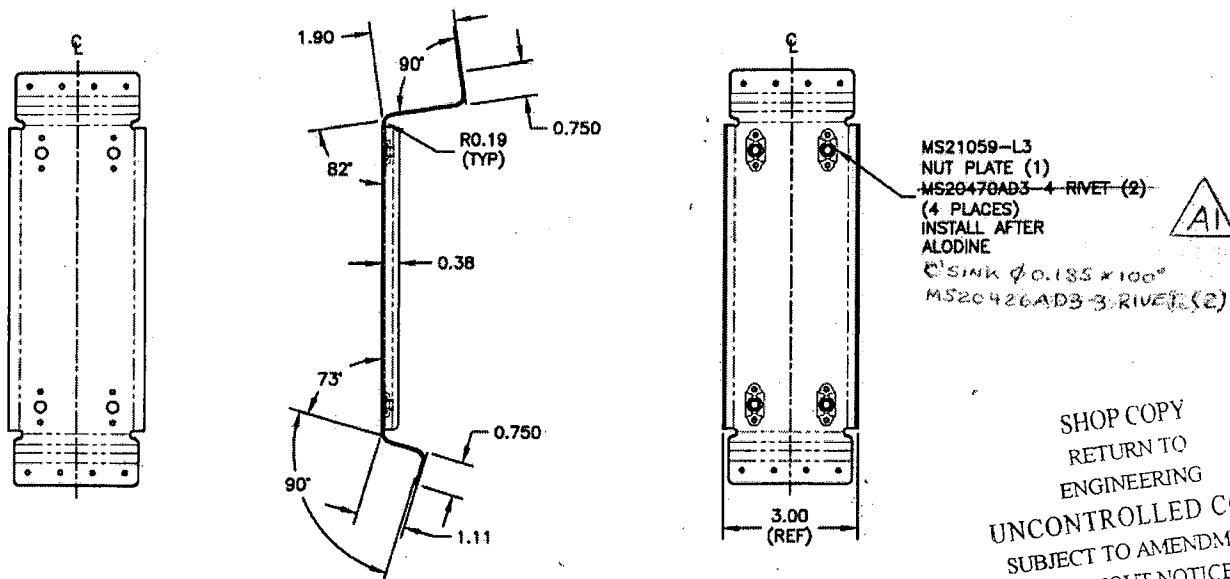
NOTE: Date & initial all entries

DARTCOPY ISSUE
C

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4

RELEASED
04.05.07 *[Signature]*

A	04.04.21	NEW ISSUE
A1	<i>[Signature]</i> 04.06.16	CHANGE RIVET; ADDED C'SINK

**D3246-1 FLAT PATTERN****D3246-1 BEND DETAIL****D3246-041 ASSEMBLY**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART AEROSPACE LTD	Work Order:	28470
Description:	Part Number:	3246-041
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>J.</u>	Prototype Approval:	
Date:	<u>09/14</u>	Date:	<u>06/05/16</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	